

NCR-19-7736



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D2010-103
Job Sheet 202384



Part No: D2010-103

Job Qty: 10 pcs

DAS
21
9-09

Part Name: Mirror Arm 369/500



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/28/19

Job Tracking No:

Due Date: 11/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP : F 02.08.21 Re-format; Added D2057 KJ/RF IPP Rev:G 08-05-27 as per ECN1195P DD
verified by:EC IPP Rev:H 08-06-20 rev.D as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - Brake NC	10 pcs		11/12/19	0.25	2.55	Small Fab - Brake - 1		DAS NOV 08 2019
							Small Fab - Brake - 2		
							Small Fab - Brake - 3		
110	Small Fab - 2 - B4B	10 pcs		11/12/19	0.00	2.07	Small Fab - 1 - B4B		DAS NOV 08 2019
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
120	Small Fab - 3 - B4B	10 pcs		11/12/19	0.00	2.07	Small Fab - 1 - B4B		DAS NOV 12 2019
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
130	QC 5	10 pcs		11/12/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
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P.T.O.

					QC 5 - 58		DAS
					QC 5 - 68	NOV 13 2019	68
					QC 5 - 9		9-89
					QC 5 - 50		
					QC 5 - 30		
					QC 5 - 40		
					QC 5 - 61		
					QC 5 - 81		
140	Powdercoat - 4 Black Sand - B4B	10 pcs	11/12/19	0.00 0.21	Powdercoat - 1 - B4B		
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B		
					Powdercoat - 4 - B4B		
150	QC 3	10 pcs	11/12/19	0.00 0.00	QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15		
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40	NOV 13 2019	DAS 40
					QC 3 - 19		9-89
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
160	Packaging 3-1 - Stock - B4B	10 pcs	11/12/19	0.00 0.00	Packaging 3 - 1 - B4B		
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
			170 QC 21 - SA	10 pcs	11/12/19
				0.00	0.00
				QC 21 - SA - 21	DAS 21 1-59
				QC 21 - SA - 70	
				QC 21 - SA - 53	

NOV 13 2019 5T351

Part Op 100 - (Punch ends and deburr as per dwg), Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727 Identify as Descriptions: D2010-103

110 - 1- Bend as per Dwg D2010 using bending Jig D2010-103T2 2- Deburr ends

120 - 1-flare before installling plug as per dwg D2010 2-Install D2057 plug as per Dwg D2010

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3), START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.049	304 Round Tube .500 X .049W	15 ft (1.5 ea)	100-Small Fab - Brake NC	5166227
D2057	Plug	10 pcs (1 ea)	110-Small Fab - 2 - B4B	5197307

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Brake NC	M304TR0.500W.049	15	49	0
110-Small Fab - 2 - B4B	D2057	10	10	0
Part Specifications				
Specifications could not be found.				

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Entered: JKDate: Nov 19/19NCR No. 19-7736

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>202384</u> Part No. <u>D2010-103</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>19-11-12</u>		Sequence #: <u>120</u>		QTY Affected: <u>1</u>		MRB (QSI042) DAS 9 9-89 <u>19-11-12</u>	
Description Work Order Deviation				Disposition			
Qty of one part was out of tolerance after bending.				Scrap destroy no replace.		Completed By NOV 12 2019 9-89 Lead hand / Supervisor DAS 9 9-89 <u>19-11-12</u> QC / QA Coordinator DAS 9 9-89 <u>19-11-12</u>	
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☒ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					